

Work Order ID 50577

July 16, 2009 8:17:28 AM



Page 1

Item ID: D3836-042
 Revision ID: A
 Item Name: Rib Assembly (Basket Lid, RH)
 Start Date: 07/17/2009 Start Qty: 2.00
 Required Date: 07/22/2009 Req'd Qty: 2.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: *MLF* Date: *09-07-16* Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3836	Rev A

100		0.00							
-----	--	------	--	--	--	--	--	--	--



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836-12- remove identification markings 13- deburr

SAD 09-07-21

(24)
2

110		0.00							
-----	--	------	--	--	--	--	--	--	--



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

=> S 09/7/22 (+2)

- 042

6

120		0.00							
-----	--	------	--	--	--	--	--	--	--



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836-1- weld D2327-3 spacer bushing as per dwg D3836-1 A/R ER316 S.S. Rod Batch: *1108160* 3- grind weld flush where indicated on dwg D

PD 09.07.23 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50577

July 16, 2009 8:17:28 AM



Page 2

Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

lp109.07.23



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

=> 509107/23



QC

Memo

0.00

Quality Control

042
(+2) f

150

Identify as per dwg & Stock Location Basket

0.00



Packaging

Memo

0.00

Packaging

PD 09.07.23

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50577

July 16, 2009 8:17:28 AM



Page 3

Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/24 *[Signature]*

MF 09-07-24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 16, 2009 8:17:28 AM

Work Order ID: 50577

Parent Item: D3836-042RevA

Parent Item Name: Rib Assembly (Basket Lid, RH)

Comments:

Start Date: 07/17/2009

Required Date: 07/22/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD		Manufactured	No			100	Each	76.0000	2.0000			
Spacer Bushing												

Warehouse Loc Qty Loc Code
Location

Premier

Mezz 78

44274 69

44365 9

Main Warehouse

ST -2

44274 -2

M304TS0.750W.065

Purchased

No

100 f

174.1729 3.7491

304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT 174.172879

110969 3.29

111148 15.96

111331 1.96

111432 0.44

111885 5.9122

112051 146.610679

2 PD 09.07.23

3.7491 SMD 09-07-21 2

Dart Aerospace Ltd

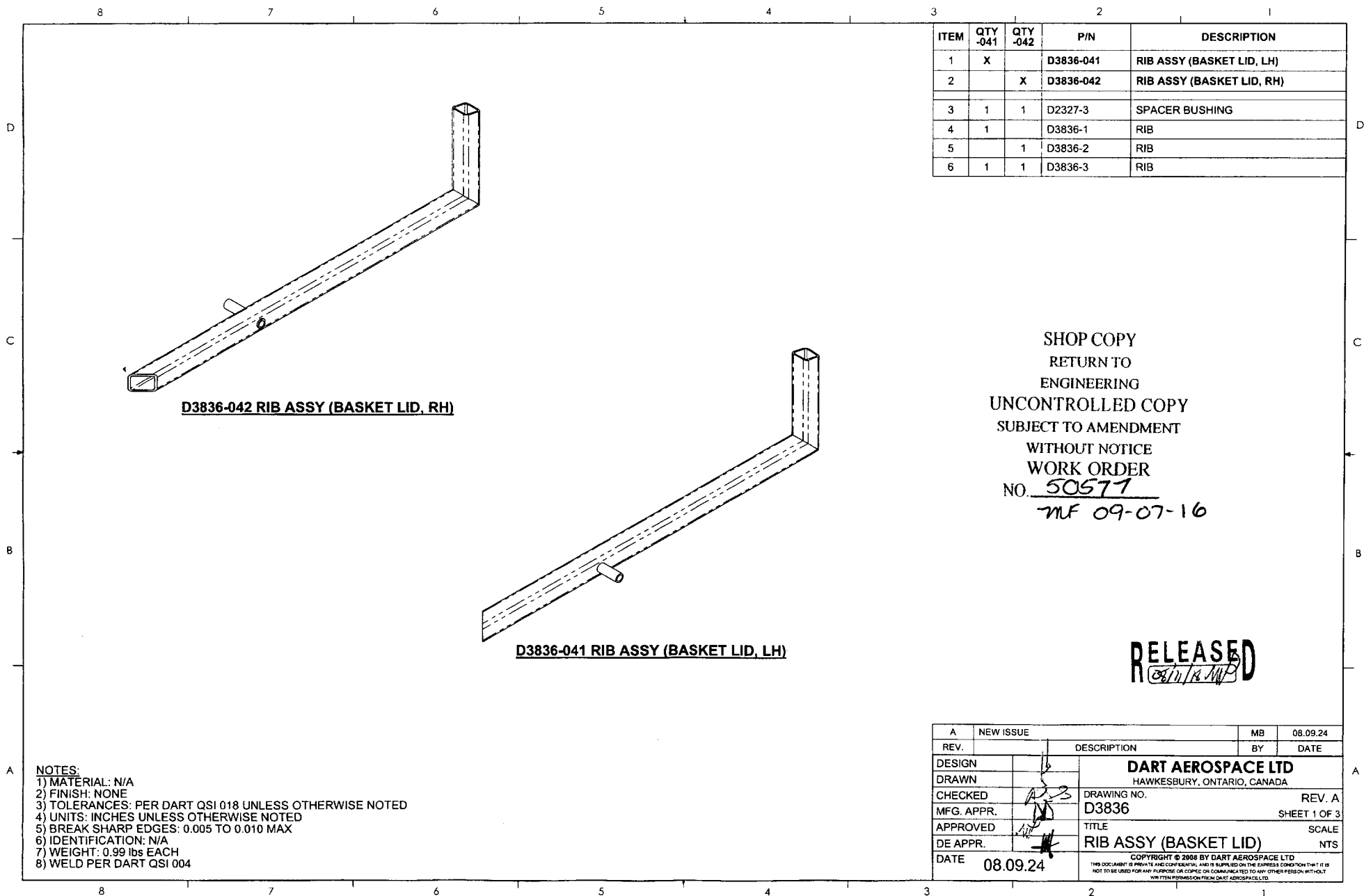
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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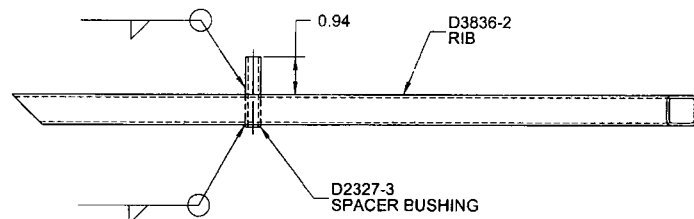
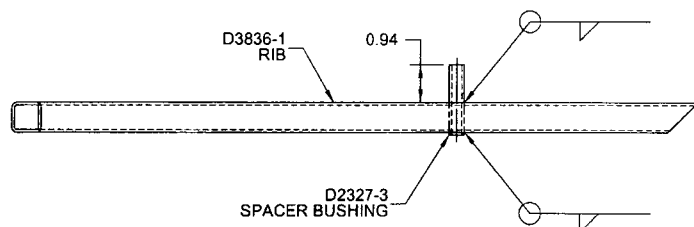
NOTE: Date & initial all entries



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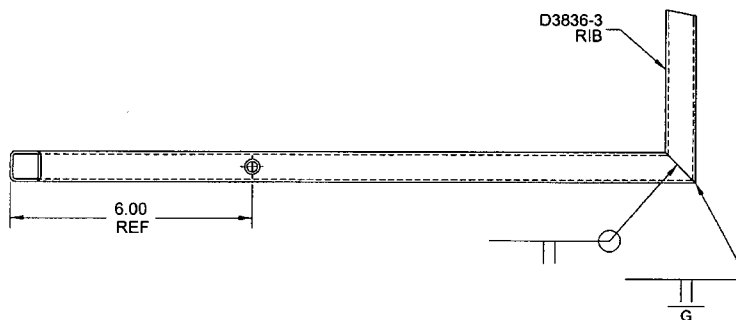
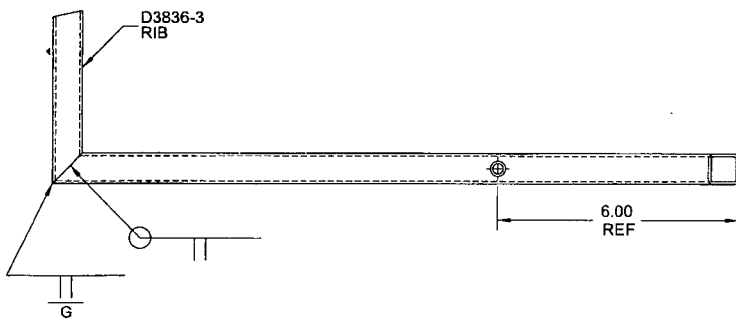
D

D



C

C



B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

A

A

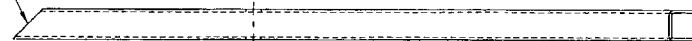
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RETURN TO
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NO. 50577
MF 09-07-16

RELEASED
8/11/18

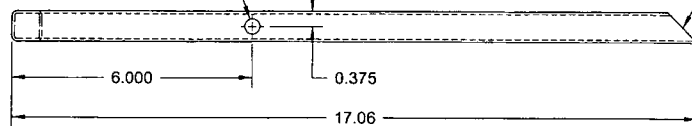
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

0.75 X 45°
CHAMFER

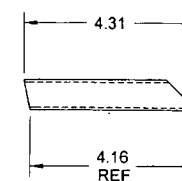


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D3836-1 RIB

0.75 X 45°
CHAMFER



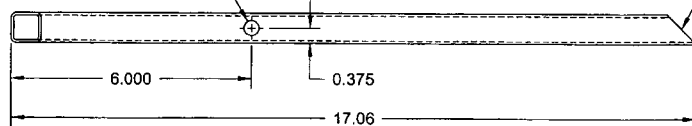
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CHAMFER

D3836-3 RIB

0.75 X 45°
CHAMFER

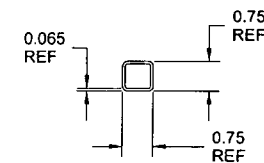


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



D3836-2 RIB

0.75 X 45°
CHAMFER



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

SHOP COPY
RETURN TO
ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 50577
MF 09-07-16

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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